

IN THE CLAIMS

Please cancel claims 1-60, all of the claims in the verified translation of PCT/DE2003/003941. Please also cancel claims 1-61 filed under Article 19 on June 29, 2004. Further, please cancel claims 1-69 as presented by KBA on December 14, 2004. Please add new claims 70-133, as follows.

Claims 1-69 (Cancelled)

70. (New) A printing blanket unit for a printing blanket cylinder of a printing press comprising:

a dimensionally stable support plate including a plate exterior surface with leading and trailing plate ends;

a printing blanket fastened on said plate exterior surface and having printing blanket ends spaced apart in a longitudinal direction of said printing blanket, and a printing blanket exterior surface; and

a filler material on at least a portion of said support plate and being embodied as a support element, said filler material engaging at least one end of said printing blanket and extending radially to at least said printing blanket exterior surface and extending from said at least one of said printing blanket ends in said longitudinal direction of said printing blanket at a length greater than 0.1 mm.

71. (New) The printing blanket unit of claim 70 further including at least one folded end leg on at least one end of said support plate and including a fold zone at a juncture

of said support plate and said end legs, said filler material being arranged at least partially on said fold zone at said at least one folded end leg.

72. (New) The printing blanket unit of claim 71 further including folded end legs at each of said support plate ends.

73. (New) The printing blanket unit of claim 72 wherein said filler material is located on both of said folded zones of both of said folded end legs.

74. (New) The printing blanket unit of claim 70 wherein said length is greater than 0.4 mm.

75. (New) The printing blanket unit of claim 70 wherein said length is less than 2 mm.

76. (New) The printing blanket unit of claim 70 wherein said length is less than 5 mm.

77. (New) The printing blanket unit of claim 70 wherein said filler material has a filler material thickness and said printing blanket has a printing blanket thickness which is less than said filler material thickness.

78. (New) The printing blanket unit of claim 71 wherein said at least one folded end

leg defines an acute angle with said support plate.

79. (New) The printing blanket unit of claim 71 wherein said at least one folded end leg is arranged at said leading end of said support plate of said printing blanket unit.

80. (New) The printing blanket unit of claim 72 wherein said folded end leg at said trailing end of said support plate forms an opening angle of between 45° and 150° with said support plate.

81. (New) The printing blanket unit of claim 80 wherein said angle is between 80° and 100° .

82. (New) The printing blanket unit of claim 80 wherein said angle is between 120° and 150° .

83. (New) The printing blanket unit of claim 71 wherein said filler material extends at least partially past said fold zone on said at least one folded end leg.

84. (New) The printing blanket unit of claim 70 wherein said filler material extends in said longitudinal direction of said printing blanket at a virtual extension of said printing blanket exterior surface.

85. (New) The printing blanket unit of claim 70 wherein said filler material extends

radially at least in part past a virtual extension of said printing blanket exterior surface.

86. (New) The printing blanket unit of claim 70 wherein said filler material engages both of said ends of said printing blanket.

87. (New) The printing blanket unit of claim 72 wherein said filler material extends around both of said fold zones.

88. (New) The printing blanket unit of claim 70 wherein when said printing blanket unit is mounted on the printing blanket cylinder, said filler material on said at least one end of said printing blanket is not connected with filler material on another end of said printing blanket.

89. (New) The printing blanket unit of claim 88 wherein said filler material on said at least one end of said printing blanket is spaced from filler material on another end of said printing blanket.

90. (New) A method for providing a printing blanket unit for use on a printing blanket cylinder of a printing press including:

providing a dimensionally stable support plate having longitudinally spaced leading and trailing plate ends and with an exterior support plate surface;

providing a printing blanket having printing blanket ends and a printing blanket exterior surface;

fastening said printing blanket on said support plate exterior surface;
providing a printing blanket unit processing device separate from the
printing blanket cylinder;
placing at least said support plate on said processing device;
adding a filler material to at least one end of said support plate in said
processing device; and
vulcanizing said printing blanket unit after adding said filler material.

91. (New) The method of claim 90 further including a mold in said processing device
and adding said filler material to said mold.

92. (New) The method of claim 91 further including adding said filler material in a
flowable state.

93. (New) The method of claim 90 further including deforming said filler material
during said adding of said filler material.

94. (New) The method of claim 90 further including folding at least one of said
support plate ends and adding said filler material after folding said at least one support
plate end legs.

95. (New) The method of claim 90 further including providing separate filler materials
at both of said ends of said support plate.

96. (New) The method of claim 90 further including folding both of said support plate end legs and adding said filler material to both of said ends of said support plate.

97. (New) The method of claim 96 further including adding said filler material after folding said end legs.

98. (New) The method of claim 90 further including arranging said printing blanket on said support plate before adding said filler material.

99. (New) The method of claim 90 further including forming an exterior surface of said added filler material and processing said filler material exterior surface.

100. (New) The method of claim 91 further including opening said mold after adding said filler material.

101. (New) The method of claim 91 further including providing at least a first mold surface and moving said at least first mold surface in a longitudinal direction of said support plate.

102. (New) The method of claim 101 further including providing a second mold surface, locating said first and second mold surfaces at leading and trailing plate ends, and moving both of said first and second mold surfaces in said longitudinal direction of said support plate.

103. (New) A method for producing a printing blanket unit for use on a printing blanket cylinder of a printing press including:

providing a dimensionally stable support plate having longitudinally spaced leading and trailing plate ends and with an exterior support plate surface;

folding at least one of said leading and trailing plate ends along a fold zone;

applying a printing blanket having longitudinally spaced printing blanket end faces and a printing blanket exterior surface to said exterior support plate surface;

providing a filler material;

applying said filler material to said support plate in an area of said fold zone; and

connecting said applied filler material to at least one of said end faces of said printing blanket.

104. (New) The method of claim 103 further including applying said filler material to both of said end faces of said printing blanket.

105. (New) The method of claim 103 further including mounting said printing blanket unit on the printing blanket cylinder and not connecting said printing blanket end faces and said filler material at said ends of said printing blanket.

106. (New) The method of claim 103 further including mounting said printing blanket unit on the printing blanket cylinder and maintaining said printing blanket end faces with

said filler material out of touch.

107. (New) A printing blanket unit for a printing blanket cylinder of a printing press comprising:

- a dimensionally stable support plate including a plate exterior surface and longitudinally spaced leading and trailing support plate ends;

- a printing blanket fastened on said support plate exterior surface and having printing blanket end faces and a printing blanket exterior surface;

- a filler material arranged on at least one of said printing blanket end faces;

- a first printing blanket unit thickness intermediate said printing blanket end faces; and

- a second printing blanket unit thickness at said at least one said printing blanket end face including said filler material, said second printing blanket unit thickness being greater than said first printing blanket unit thickness, said printing blanket unit end face including said filler material extending radially beyond a virtual exterior of said printing blanket unit intermediate said end faces.

108. (New) The printing blanket unit of claim 107 wherein, with said printing blanket unit applied to the printing blanket cylinder, a first radius of said printing blanket unit in an area of said at least one end face with said filler material is greater than a second radius of said printing blanket unit intermediate said end faces.

109. (New) The printing blanket unit of claim 107 wherein said filler material increases

said second printing blanket unit thickness.

110. (New) The printing blanket unit of claim 107 wherein said second printing blanket unit thickness is less than 10 mm greater than said first printing blanket unit thickness.

111. (New) The printing blanket unit of claim 70 wherein said support plate is metal.

112. (New) The printing blanket unit of claim 70 wherein said printing blanket is multi-layered.

113. (New) The printing blanket unit of claim 70 wherein said filler material is one piece.

114. (New) The printing blanket unit of claim 70 wherein said printing blanket is material different from said filler material.

115. (New) The printing blanket unit of claim 70 wherein said printing blanket is the same material as said filler material.

116. (New) The printing blanket unit of claim 70 wherein said filler material is placed on said support plate before said printing blanket.

117. (New) The printing blanket unit of claim 108 wherein said first radius is greater

than said second radius by less than 10 mm.

118. (New) The printing blanket unit of claim 117 wherein said first radius is greater than said second radius by less than 5 mm.

119. (New) The printing blanket unit of claim 70 further including a forme cylinder in contact with said printing blanket unit on the printing blanket cylinder.

120. (New) The printing blanket unit of claim 119 further including at least one printing plate on the forme cylinder.

121. (New) The printing blanket unit of claim 119 further including at least one interruption on a surface of said forme cylinder.

122. (New) The printing blanket unit of claim 120 wherein said filler material and said printing plate mutually support each other.

123. (New) The printing blanket unit of claim 70 wherein said printing blanket is on top of said filler material.

124. (New) The method of claim 103 further including making said support plate of metal.

125. (New) The method of claim 103 further including providing said printing blanket being multi-layered.

126. (New) The method of claim 103 further including providing said filler material as one piece.

127. (New) The method of claim 103 further including providing said printing blanket of a material different from said filler material.

128. (New) The method of claim 103 further including providing said printing blanket and said filler material of the same material.

129. (New) The method of claim 103 further including applying said filler material to said printing blanket unit before mounting said printing blanket unit on the printing blanket cylinder.

130. (New) The method of claim 103 further including providing a forme cylinder and contacting said forme cylinder with the printing blanket cylinder.

131. (New) The method of claim 130 further including providing at least one printing plate on said forme cylinder.

132. (New) The method of claim 130 further including providing at least one surface

interruption on a circumferential surface of said forme cylinder.

133. (New) The method of claim 131 further including using said filler material and said printing plate for mutually supporting each other.